

Work Order ID 56226

Tuesday, February 16, 2010 3:01:58 PM



UNPAINTED

Page 1

Item ID: D350-591-213UP

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Short LH

Start Date: 2/17/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 2/22/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 10-2-16 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-213 CHG003

8/10/02/22

8/10/02/19

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2622-120 extrusion to 59.75" long as per Dwg D3078
2-Drill extrusion as per Dwg D3078 using Jig DT8680 for rivets.
3-Deburr

8/10.02.17

+1 2

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/02/17

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Date:

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Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY
2-Weld Support using Jig DT8681, weld Fwd End Plate as per QSI 004 & Dwg D3072
A/R Aluminum Rod *M110130*
3-Grind End Plate flush *M11131*

Sh 10.02.17

140

0.00



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

Memo

0.00

1 0 BE 10/02/17

150

0.00



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

Siola 17

(14)

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

10.02.17

1 0

Hand Finishing

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

= 7 m-h w/02/17

(14)

Quality Control

180

Large Fab

0.00



Large Fab

Memo

0.00

10.02.17

1 0

Large Fab

Rivet Leg Assembly as per Dwg D3078.

W/O:		WORK ORDER CHANGES					
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Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

BE

10.02.17

Done @ seq. 220

200



Large Fab

Large Fab

Large Fab

Memo

1-Bevel Aft end for welding
2-Inspect for foreign object as per QSI 024
3-Weld Aft End Plate as per QSI 004 & Dwg D3078
A/R Aluminum Rod m11311
4-Grind End Plate flush

0.00

0.00

BE 10.02.17

1 0

210



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

1 0 BE 10/02/18

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Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

10/02/08

Memo

0.00

(70)

230



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

attn: unpainted

DH BR 10-02-18.

250



HandFinish

Hand Finishing

Wing Walk as per dwg QSI005 4.4 Batch

0.00

Memo

A - MF 10-2-16

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

260

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

8/10/12/22

11/4

270

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10-2-10

DSQ

280

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8/10/12/22

4/4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Required Date: 2/22/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

290

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-591-213

Location: e2

PPP Rev: _____

10-2-22 S

300

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

10-2-22
MP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Page 1

Work Order ID: 56226

Parent Item: D350-591-213UP

Parent Item Name: Heli-Access-Step, Short LH

Comments:

Start Date: 2/17/2010

Required Date: 2/22/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2622-120C

Manufactured

No

Each

162.7400

0.5000



Step Extrusion

12 10.02.17

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

162.74

48612

3.12

52026

36.62

55214

123

D3067-1

Manufactured

No

Each

53.0000

1.0000



End Plate

12 10.02.17

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

53

53784

53

D3063-1

Manufactured

No

Each

25.0000

1.0000



Support

12 10.02.17

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

25

51237

25

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Start Date: 2/17/2010

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Comments:

Start Qty: 1.00

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20600-AD4W4  Rivets		Purchased	No				Each	1,203.000	16.0000		<i>10.02.17</i>	

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1203	
110731	215	
111359	46	
111477	74	
<u>112314</u>	344	<i>16</i>
112385	24	
113368	500	

D3066-1

Manufactured No



Spacer

42.0000 2.0000



10.02.17

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	42	
51545	11	
<u>53783</u>	31	<i>2</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Start Date: 2/17/2010

Required Date: 2/22/2010

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3065-041 Step Leg Assembly Hi		Manufactured	No				Each	60.0000	1.0000		<i>10.02.17</i>	

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
WA	60	
53795	30	
55450	30	

D3067-1 End Plate		Manufactured	No				Each	53.0000	1.0000		<i>10.02.17</i>	
--------------------------	--	--------------	----	--	--	--	------	---------	--------	--	-----------------	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	53	
53784	53	

AN3-35A Bolt		Purchased	No				Each	201.0000	2.0000		<i>10-2-18 sl</i>	<i>(12)</i>
---------------------	--	-----------	----	--	--	--	------	----------	--------	--	-------------------	-------------

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	201	
106993	12	
110467	1	
112314	188	

W/O:		WORK ORDER CHANGES					
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Comments:

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---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2856-400

Manufactured

No

f

262.5521

0.6000



Abraison Strip

10-2-18 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST403

262.5520842

50593

141.312084

52563

121.24

1X

cut qty of 1 at 4.00" X 7.20" as per dwg (D2856-400-720)

AN4-11A

Purchased

No

Each

450.0000

6.0000



Bolt

10-2-18 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

450

110382

450

Each

0.0000

12.0000

AN960JD416

Purchased

No



Washer

6

M113706 10-2-18 SP 1P

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Start Qty: 1.00

Required Qty: 1.00

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---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2230-1		Manufactured	No				Each	128.0000	2.0000			
---------	--	--------------	----	--	--	--	------	----------	--------	--	--	--



Lug



10-2-18 SP

Warehouse	Loc Qty	Loc Code
-----------	---------	----------

Location

Main Warehouse

ST

4

51761

4

Main Warehouse

ST476

124

54755

124

2

MS21042L3

Purchased

No



Nut

2,665.000 2.0000



10-2-18 SP

12

Warehouse	Loc Qty	Loc Code
-----------	---------	----------

Location

Main Warehouse

ST

2659

110844

35

111274

27

111668

52

112314

289

112385

498

113523

58

113537

700

113644

1000

2

Main Warehouse

ST139

6

111668

6

Tuesday, February 16, 2010 3:01:58 PM

Shop Packet Print

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AN4-13A

Purchased

No

Each

261.0000

4.0000



Bolt



10-2-18 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

261

113359

61

113749

200

17406

0

51764

0

D2732

Manufactured

No

f

103.0410

1.0526



Rubber Extrusion



10-2-18 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

103.041

38500

20.62

43118

82.421

cut qty of 4 at 3.00" as per dwg(D2732-030) - measure 5/10/16

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---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2230-3

Manufactured

No

Each

51.0000

2.0000



Lug

10-2-185

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

7

50306

5

51568

2

Main Warehouse

ST476

44

55310

44

AN960JD10

Purchased

No

Each

0.0000

4.0000



Washer

MS21042L4

Purchased

No

Each

2,320.000

6.0000



Nut

11/13288 10-2-185

102-18

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2320

102552

6

104248

6

110507

184

111827

1130

113422

994

15924

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, February 16, 2010 3:01:58 PM

Work Order ID: 56226



Parent Item: D350-591-213UP



Parent Item Name: Heli-Access-Step, Short LH

Start Date: 2/17/2010

Required Date: 2/22/2010

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN4-16A

Purchased

No

Each

84.0000

4.0000



Bolt



10-2-18 SP (10)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

84

112969

82

18949

2

27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3078	REV. A SHEET 1 OF 2
DATE 02.09.11		TITLE STEP ASSEMBLY, HI SHORT SCALE NTS	
A	02.09.11	NEW ISSUE	

RELEASED
02.09.20 *#*

56226

Part No.	Description	QTY -041	QTY -042
D3078-041	Step Assembly, High Short (LH)	X	
D3078-042	Step Assembly, High Short (RH)		X
D2622-60	STEP EXTRUSION	1	1
D3063-1	SUPPORT	1	1
D3065-041	LEG ASSEMBLY	1	1
D3066-1	SPACER	2	2
D3067-1	END PLATE	2	2
MS20600AD4W4	RIVET	16	16

GENERAL NOTES:

- 1) -041 SHOWN, FOR -042 INSTALL D3063-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

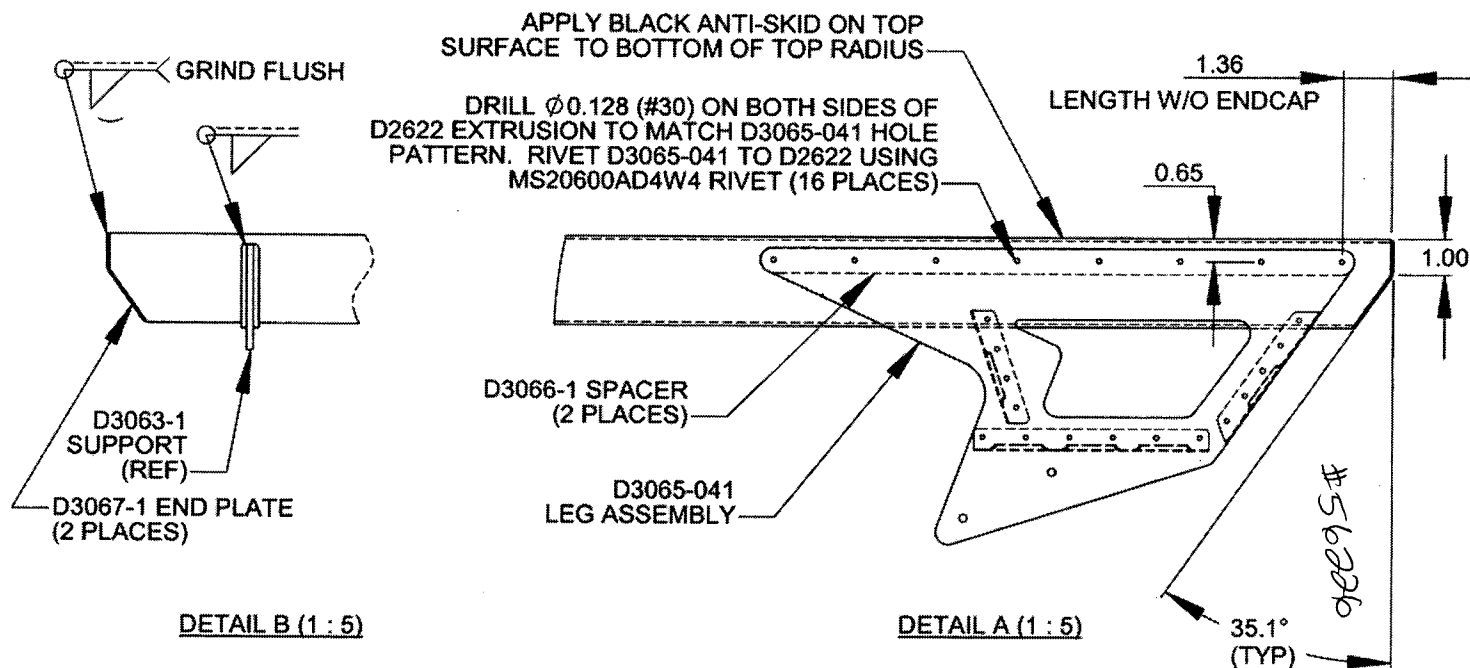
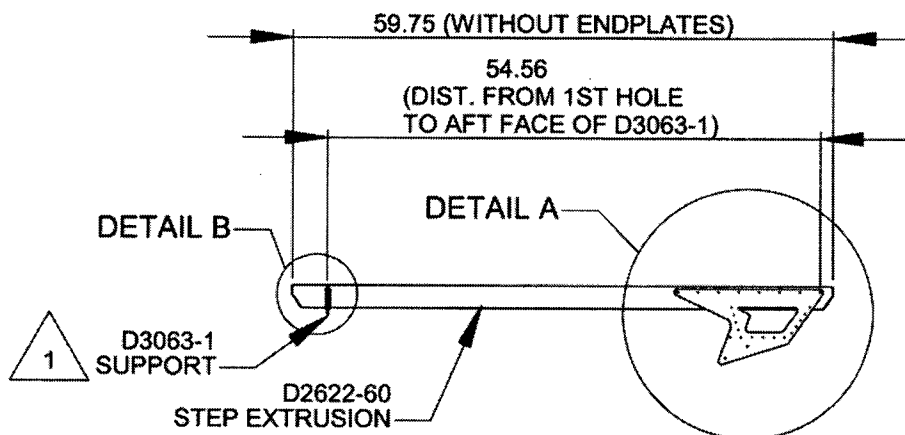


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
DATE		D3078	SHEET 2 OF 2
02.09.11		TITLE	SCALE
		STEP ASSEMBLY, HI SHORT	1:20

RELEASED
02.09.2004

58.39

D.O.I



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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
	X							D350-591-212	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
		X						D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
			X					D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
				X				D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
					X			D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
						X		D350-591-311	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
							X	D350-591-312	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G OR EARLIER
AND
INSTRUCTIONS OF CONTINUED AIRWORTHINESS ICA-D350-591 REV. 2 OR EARLIER
REF CANADIAN STC: SH92-6
REF FAA STC: SH967NE

For D350-591-213/-214/-215/-216 steps, customers have the option of installing D2732-030 cushion under the clamps to accommodate varying crosstube diameters and to improve fit, as indicted in Installation Instructions D350-591. This Service Instruction adds longer AN4-16A bolts to the parts list to allow installation of these cushions. See Figure 1 on sheet 2 of this service instruction for reference. Installation of the D2856-400-720 Abrasion Strips per Installation Instructions D350-591 is not required when the cushions are installed.

For D350-591-213/-214/-215/-216 steps at CHG 003, the parts list of D350-591 Rev. G and ICA-D350-591 Rev. 2 is amended as follows:

ADD:

Qty -213	Qty -214	Qty -215	Qty -216	Part Number	Description
X				D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
	X			D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
		X		D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
			X	D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
4	4	4	4	AN4-16A	BOLT

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED


BY: D. SHEPHERD (DE # 02)

DATE: 09.08.05
CERT. NO.: SH92-6
ISSUE NO.: 11

A	NEW ISSUE	RF	09.08.05
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO.	REV. A
CHECKED	RF	DSI 9472	SHEET 1 OF 2
MFG. APPR.	N/A	TITLE	SCALE
APPROVED	N/A	BOLT ADDITION	NTS
DE APPR.	N/A	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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